

Work Order ID 65564

January 19, 2011 1:58:14 PM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

Suloc/21

ck for ch 11/01/21

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

ES 11/01/20

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****

Suloc/20

x1
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65564

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Page 2

Item ID: D412-630-031

Accept

Setup Start

Revision ID:

Stop

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11 Start Qty: 1.00

Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/2011

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subtotal

x1
LH

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: 31

PPP Rev: 10

1/19/11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65564

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Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/24
MF
11-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 19, 2011 1:57:24 PM

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)




Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP REV. A	05.11.21	NEW ISSUE	EC
	IPP REV. B	05.12.19	updated pick list	EC
	IPP REV. C	07.11.12	ecn 1019,no chg	EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			130	Each	28.0000	1	11/1/2015			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				28					
				116075				28					
AN310-5  NUT		Purchased	No			130	Each	47.0000	2	11/1/2015			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				47					
				114830				47					
AN3C5A  Bolt		Purchased	No			130	Each	1,028.000	3	11/1/2015			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				1028					
				114330				11					
				115015				13					
				115371				100					
				115422				100					
				115594				6					
				115835				198					
				116419				500					
				116549				100					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

AN44-C12
eyebolt

Purchased No

130 Each

11.0000



1/1/2011

Location

Loc Qty

Loc Code

ST362

11

114669

11

AN4C15
BOLT

Purchased No

130 Each

19.0000



1/1/2011

Location

Loc Qty

Loc Code

ST358

19

114669

19

AN5C11
BOLT

Purchased No

130 Each

41.0000



1/1/2011

Location

Loc Qty

Loc Code

ST337

41

113950

11

114801

30

AN5C15
BOLT

Purchased No

130 Each

17.0000



1/1/2011

Location

Loc Qty

Loc Code

ST338

17

114669

17

AN960C10
WASHER

NAS1149C0363
R

Purchased No

130 Each

0.0000



1/1/2011

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased No

130 Each

159.0000

1

1



WASHER



11/1/00

Location

Loc Qty

Loc Code

ST347

159

102842

59

112532

100

D3454-1

Manufactured No

130 Each

26.0000

1

1



Bushing



11/1/00

Location

Loc Qty

Loc Code

ST058

26

58555

26

D3454-3

Manufactured No

130 Each

25.0000

2

2



Bushing



11/1/00

Location

Loc Qty

Loc Code

ST058

25

56420

25

D3454-5

Manufactured No

130 Each

8.0000

2

2



Bushing



11/1/00

Location

Loc Qty

Loc Code

ST058

8

58556

8

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3455-1

Manufactured No

130

Each

28.0000

4



Spacer



11/1/2008

Location

Loc Qty

Loc Code

ST058

28

56525

3

59469

25

4

D3455-3

Manufactured No

130

Each

15.0000

2



Spacer



11/1/2008

Location

Loc Qty

Loc Code

ST058

15

56047

7

58559

8

2

D3462-041

Manufactured No

130

Each

5.0000

1



Bracket Assembly



11/1/2008

Location

Loc Qty

Loc Code

ST198A

5

56063

1

60572

4

1

MS21043-3

Purchased No

130

Each

1,677.000

3



Nut



11/1/2008

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1601

112314

1601

3

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

MS24665-227

Purchased

No

130

Each

38.0000

2

12



COTTER PIN



1-11/20 SF

Location

Loc Qty

Loc Code

ST309

38

113845

38

MS24665-229

Purchased

No

130

Each

167.0000

2

2



COTTER PIN



1-11/20 SF

Location

Loc Qty

Loc Code

ST309

167

111041

167

NAS1515H5

Purchased

No

130

Each

184.0000

1

1



Washer



1-11/20 SF

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

140

109430

140

D3463-041

Manufactured

No

110

Each

2.0000

1

1



Step Weldment Assembly



1-11/20 SF

Location

Loc Qty

Loc Code

ST494

2

56064

2

January 19, 2011 1:57:26 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3443-043

Manufactured No

110 7 Each 3.0000

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

3

56062

3

D3443-041

Manufactured No

110 7 Each 4.0000

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

4

56061

4

D3443-9

Manufactured No

110 7 Each 6.0000

2



Pin

Location

Loc Qty

Loc Code

ST056

6

58552

6

D3454-7

Manufactured No

110 7 Each 18.0000

2



Bushing

Location

Loc Qty

Loc Code

ST058

18

55608

1

59256

17

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3455-1
Spacer

Manufactured No

110 Each

28.0000

2

2

Location

Loc Qty

Loc Code

ST058

28

56525

3

59469

25

D3465-1
Washer

Manufactured No

110 Each

26.0000

1

1

Location

Loc Qty

Loc Code

ST059

26

46134

26

AN4CH3
SS Bolt

Purchased No

110 Each

18.0000

2

2

Location

Loc Qty

Loc Code

ST355

18

114801

18

AN4C14
BOLT

Purchased No

110 Each

22.0000

1

1

Location

Loc Qty

Loc Code

ST358

22

113899

2

114669

20

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 1:57:27 PM

Page 8

Work Order ID: 65564

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

AN310-4

Purchased

No

110

Each

28.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

28

116075

28

AN310-7

Purchased

No

110

Each

49.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

49

114784

49

MS24665-227

Purchased

No

110

Each

38.0000

1

1



COTTER PIN

Location

Loc Qty

Loc Code

ST309

38

113845

38

MS24665-302

Purchased

No

110

Each

27.0000

1

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

27

113644

27

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

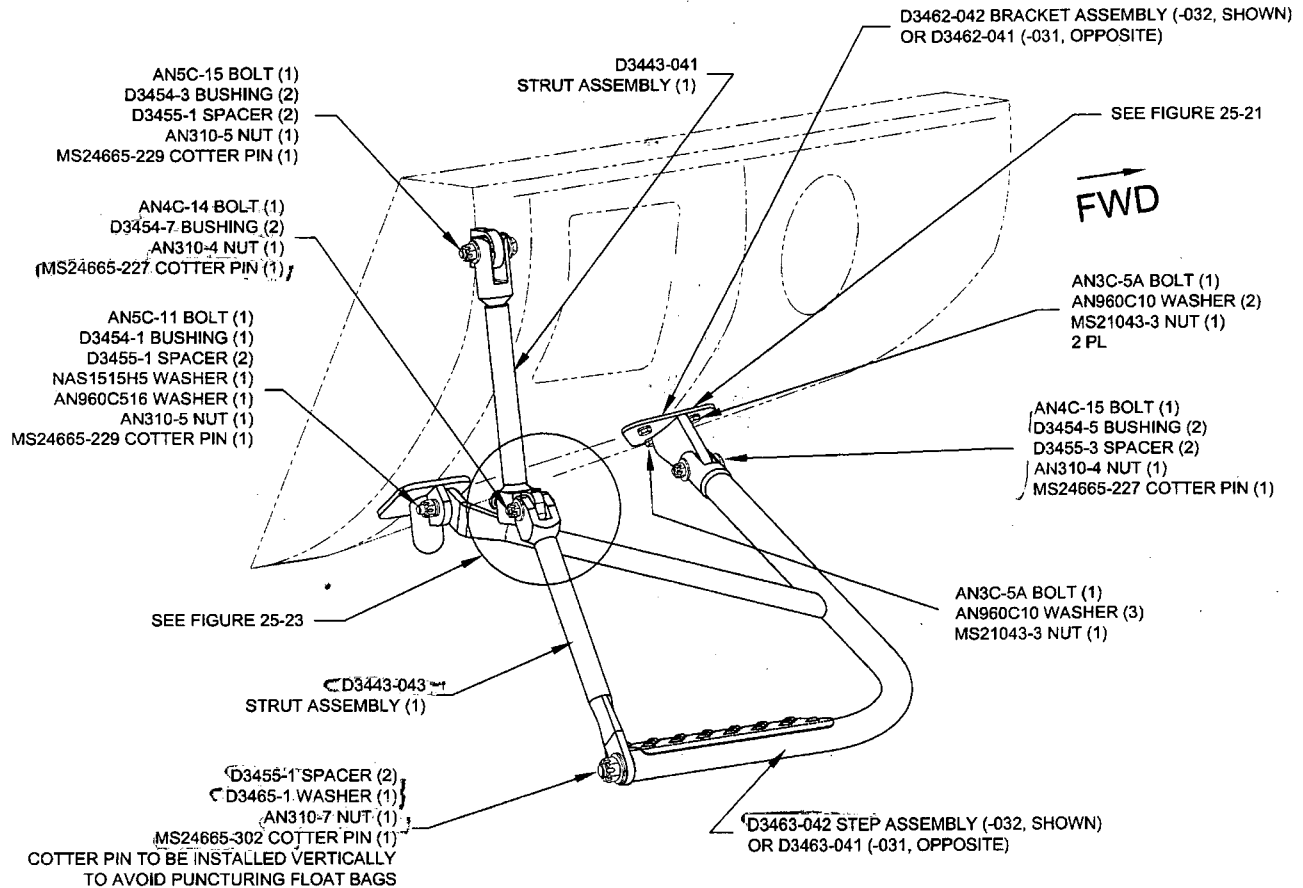


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

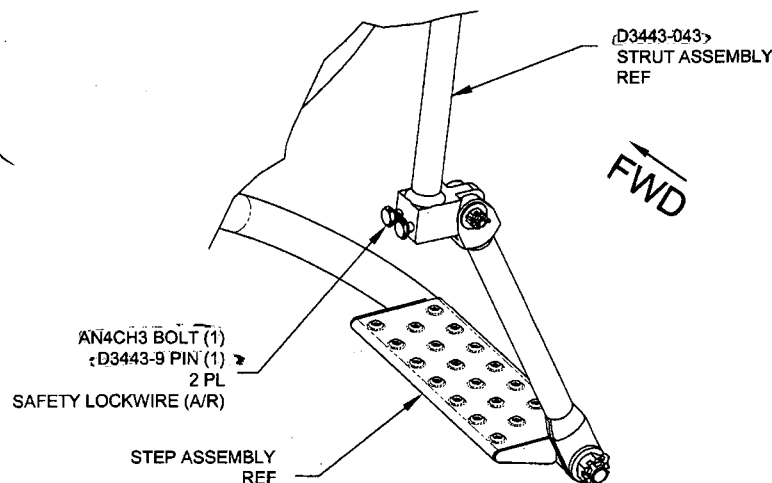


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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25-00-00

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

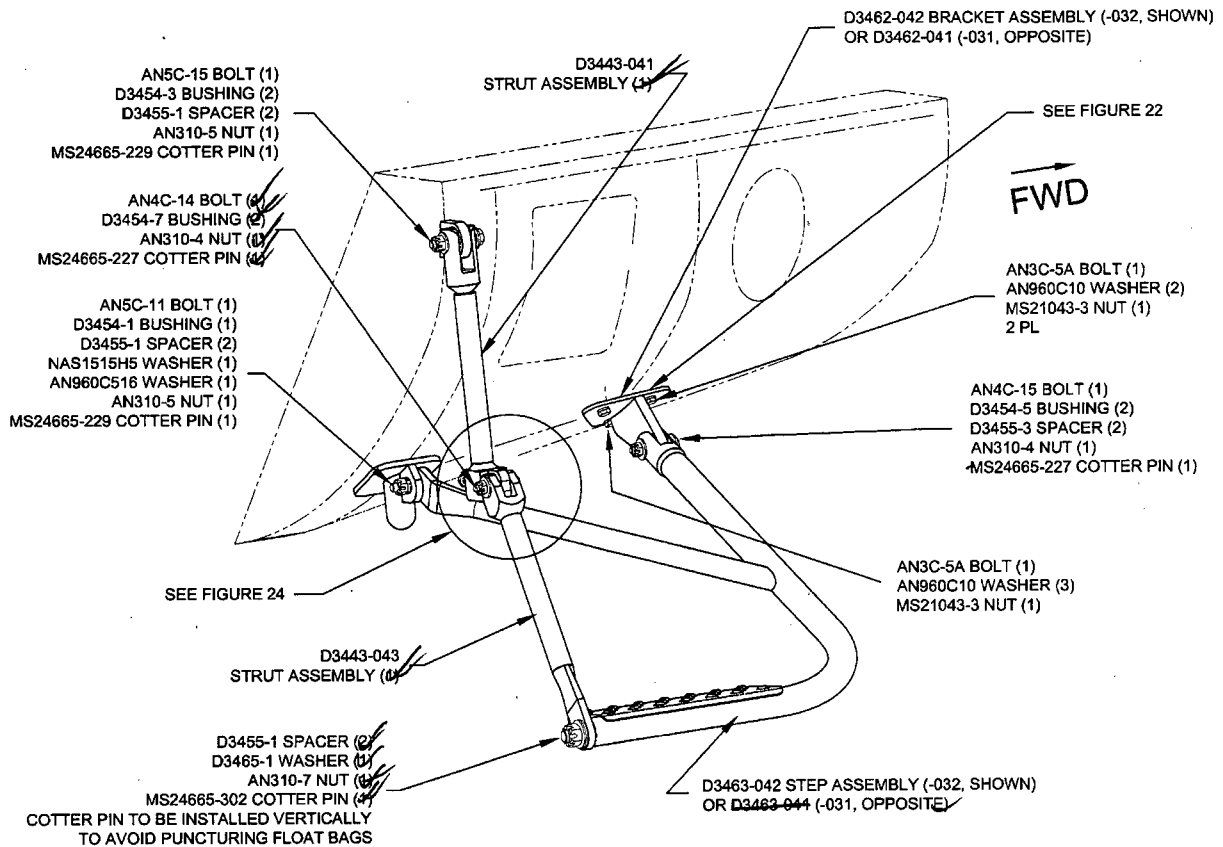


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

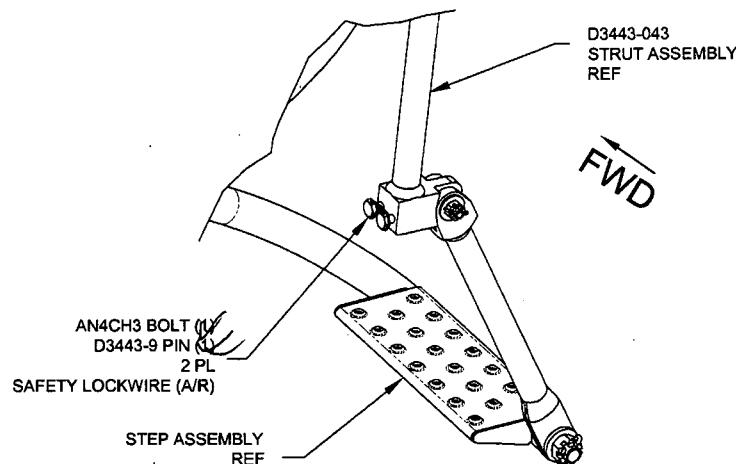
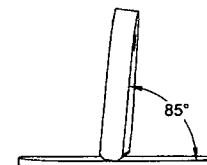
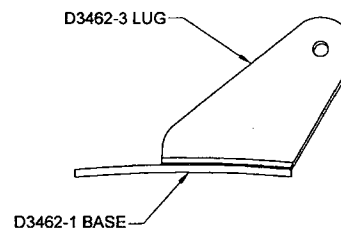
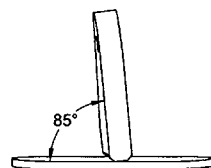
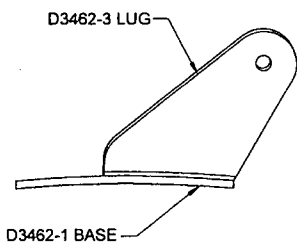
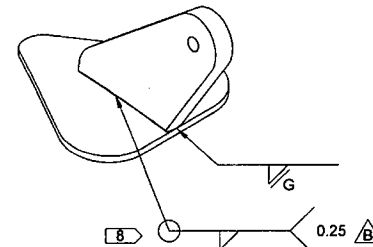
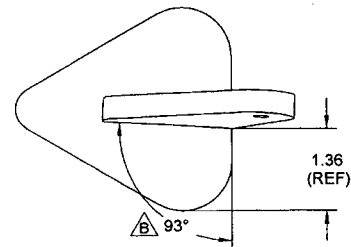
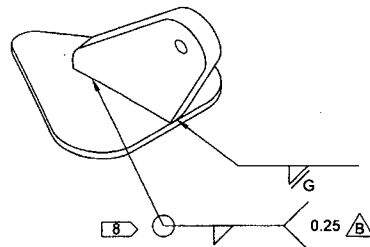
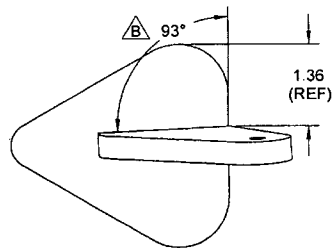


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



REFERENCE ONLY

D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3462	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		BRACKET ASSEMBLY	1:2
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.24		